

Work Order ID 65476

January 18, 2011 10:31:10 AM



Page 1

Item ID:	D3480-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Eyeball Inlet Adapter					
Start Date:	1/18/11	Start Qty:	2.00		Cust Item ID:	
Required Date:	1/31/11	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/01/18</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3480	Rev C								
100		0.00							
	Small Fab								
Small Fab		0.00							
Small Fab	Memo 1-Spot weld as per dwg D3480 2-Cut tube flush as per dwg D3480 3-Debur								
110		0.00							
	QC11- Inspect spot weld per QSI004								
QC		0.00							
Quality Control	Memo								
120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC		0.00							
Quality Control	Memo								

(2X)

(PTO)

=> M-L 11/01/26

SB 11/01/26

(2)

SB 11/01/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3480-041 PAR #: _____ Fault Category: Small Sub NCR: Yes No DQA: ✓ Date: 11/01/28
 Resolution: rework Disposition: rework QA: N/C Closed: ✓ Date: 11/01/28

NCR: <u>65476</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10-01-26</u>	<u>100</u>	<u>- upon spot welding 1 spot weld has a minor blow-out.</u> <u>R.C. process</u>	<u>[Signature]</u>	<u>fill affected area with weld - stainless steel per ASKEY</u> <u>Burr flush.</u>	<u>CPL</u> <u>11-01-26</u> <u>[Signature]</u> <u>11/01/26</u>	<u>SP</u> <u>11/01/27</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>11-01-26</u>

NOTE: Date & initial all entries

Work Order ID 65476

January 18, 2011 10:31:10 AM



Page 2

Item ID: D3480-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyeball Inlet Adapter

Start Date: 1/18/11 Start Qty: 2.00



Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: 235

0.00

Memo

PDP
65463

0.00

11/01/27 (20)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/01/27

11-01-27
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 18, 2011 10:31:09 AM

Page 1

Work Order ID: 65476

Parent Item: D3480-041

Parent Item Name: Eyeball Inlet Adapter



Start Date: 1/18/11

Required Date: 1/31/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev. A 06.02.07 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3480-3 Tube		Manufactured	No			100	Each	3.0000	1	2		SP 11/01/11	
-----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	-------------	--

Location	Loc Qty	Loc Code
ST064	3	

D3480-5 Eyeball Adapter Flange		Manufactured	No			100	Each	1.0000	1	2		SP 11/01/11	
-----------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	-------------	--

Location	Loc Qty	Loc Code
ST064	1	
64666	1	

B 65 498

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

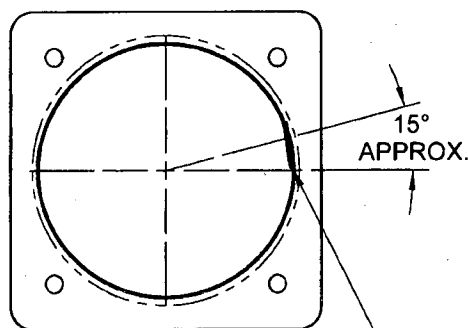
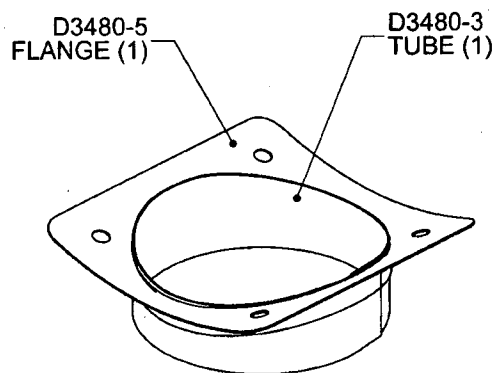
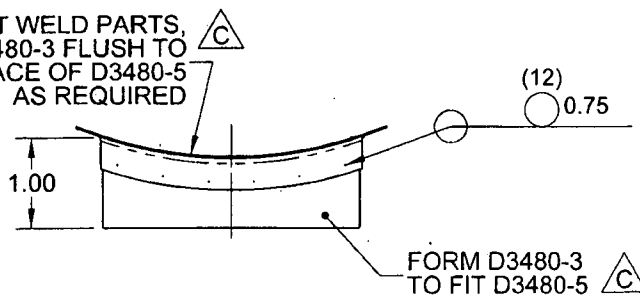
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. C SHEET 1 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2
A	06.02.06	NEW ISSUE	
B	06.08.29	D3480-3 0.50 was 0.40/D3480-3F 8.930 was 9.330	
C	08.12.19	D3480-3 PICTORIAL CHG PER D3480-3F (SHT 1 & 4); ADD/REV TOL (SHT 3-5); ADD MFG NOTE (SHT 4); MATL SPEC WAS MIL-S-5019	

RELEASE
[Signature]ALIGN WELD
SEAM OF D3480-3
AS SHOWNSPOT WELD PARTS.
TRIM D3480-3 FLUSH TO
SURFACE OF D3480-5
AS REQUIREDSHOP COPY
RETURN TO
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WORK ORDER
NO. 65476
*[Signature]***D3480-041 EYEBALL INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

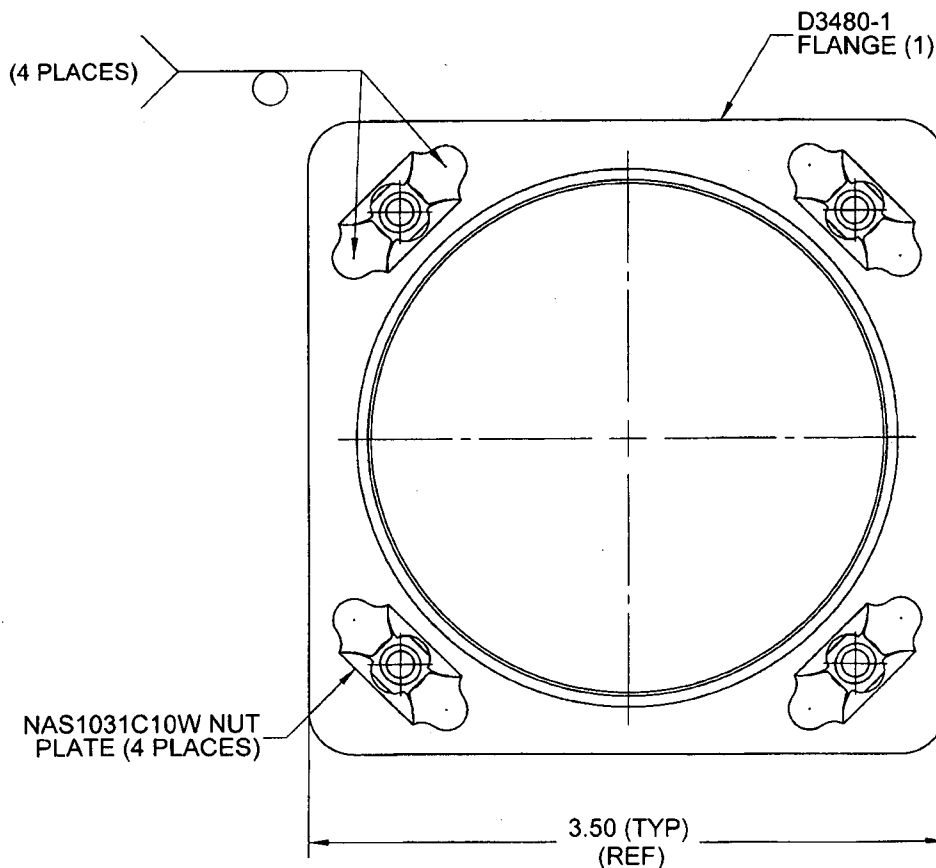
QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3480	REV. C SHEET 2 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:1

RELEASE
09/01/30 M P U

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NO. 65476

D3480-043 EYEBALL ADAPTER**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

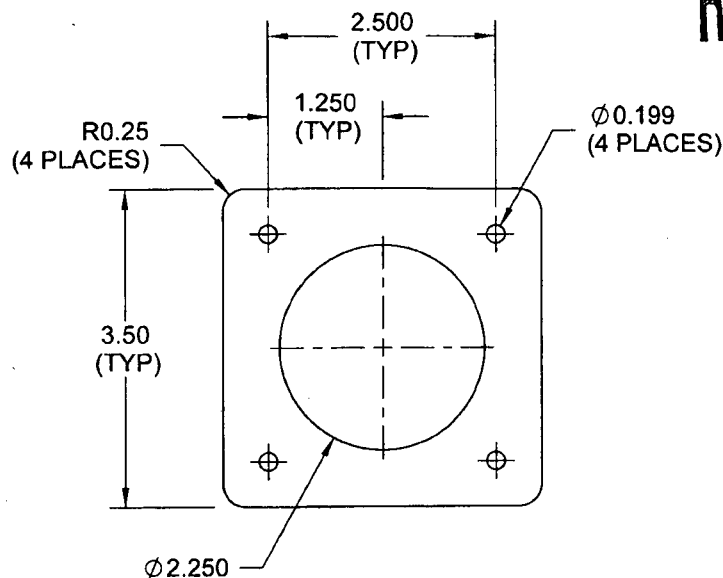
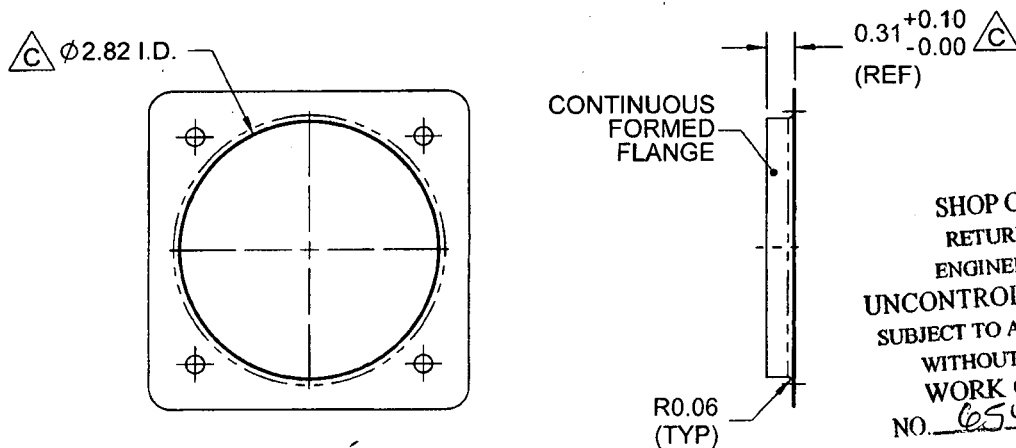
QTY -043	P/N	DESCRIPTION
X	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

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DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2

RELEASED
9/21/20 MP**D3480-1F FLAT PATTERN****D3480-1 FLANGE**
(MAKE FROM D3480-1F)**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle C$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

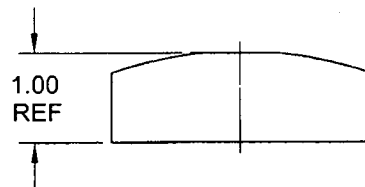
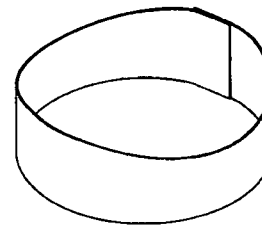
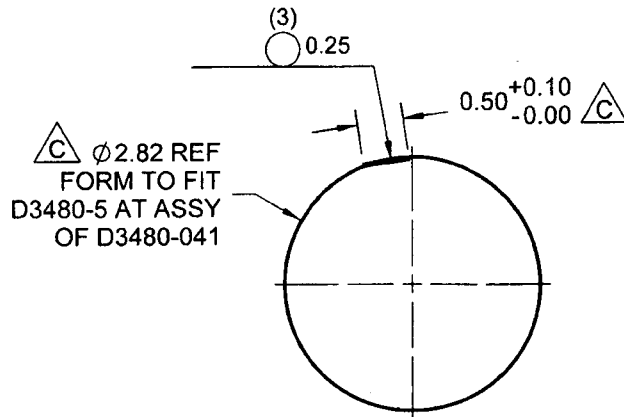
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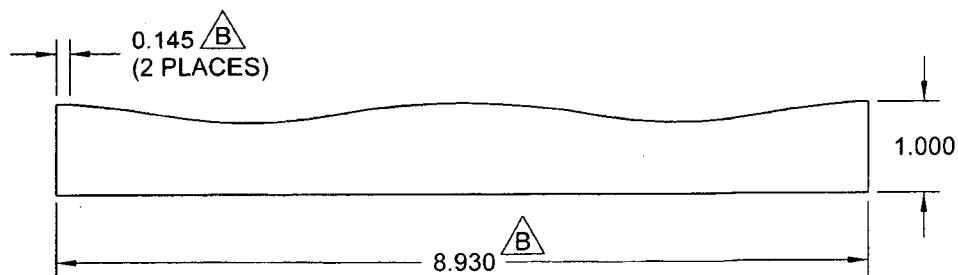
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DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2

RELEASE
9/6/30 M.D.**D3480-3 TUBE**

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**D3480-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle C$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

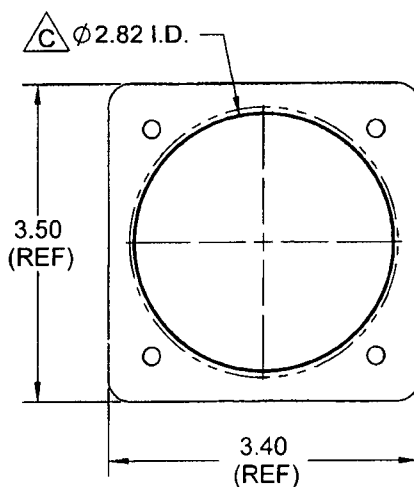
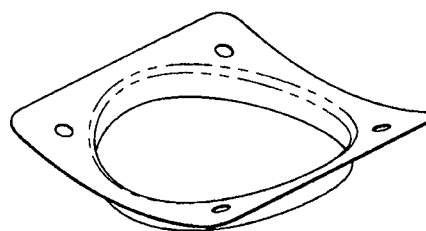
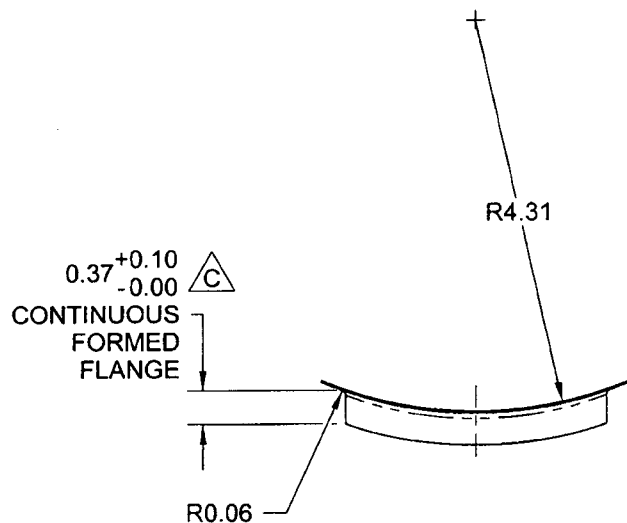
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. C SHEET 5 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2

RELEASED
09/01/20 11/11



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D3480-5 EYEBALL ADAPTER FLANGE

NOTES:

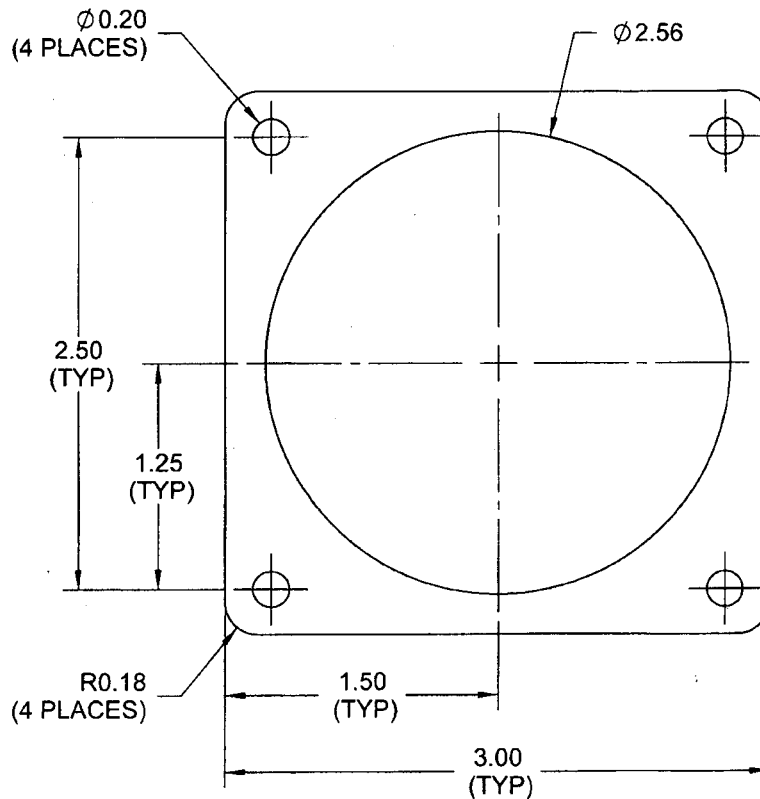
- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PA</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. C SHEET 6 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:1

RELEASED
9/6/30 MP

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D3480-7 GASKET**NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 87

EMPLOYEE: Marc Gregory

PART NUMBER: D.3480-041

JOB NUMBER: B65474

MATERIAL TYPE: 304 L

MATERIAL THICKNESS: .013

GROUP SPECIFICATION

- ☐ Group 1: Aluminum & magnesium
☐ Group 2: Iron; nickel; cobalt
☒ Group 3: Titanium SS

TEST RESULTS

	PASS.	FAIL
VISUAL:	[<u>/</u>]	[]
PENETRATION:	[<u>/</u>]	[]
PULL STRENGTH:	[<u>/</u>]	[]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 11/01/27

QUALIFIER: SB